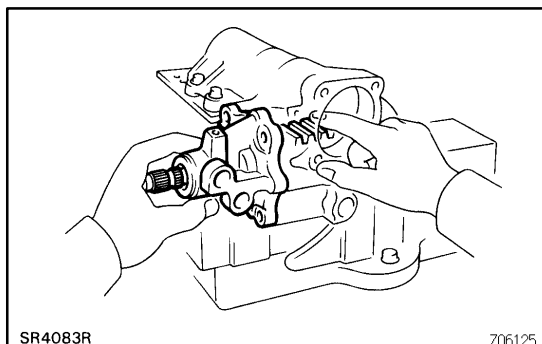
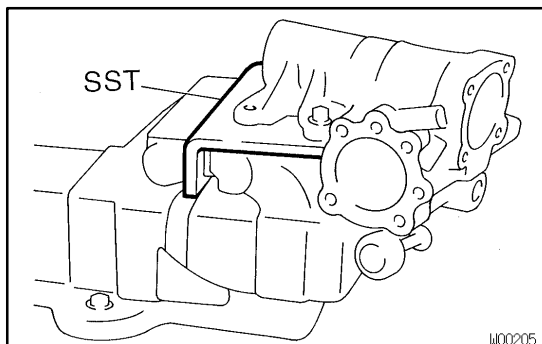


REASSEMBLY

NOTICE:

When using a vise, do not overtighten it.

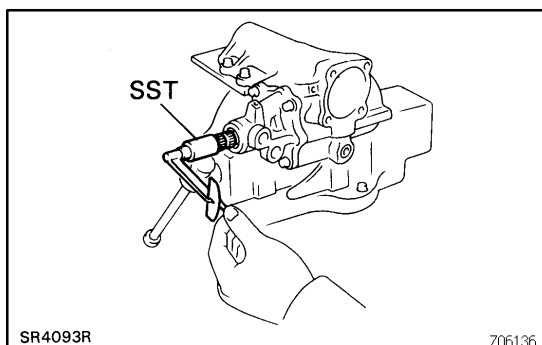
1. COAT WITH MOLYBDENUM DISULFIDE LITHIUM BASE GREASE (See page [SR-33](#))
2. INSTALL WORM GEAR VALVE BODY ASSEMBLY
 - (a) Coat 2 new O-rings with power steering fluid and install them to the gear housing.
 - (b) Secure the gear housing on SST and clamp SST in vise.
SST 09630-00014 (09631-00142)



- (c) Install the valve body assembly while supporting the worm gear with your fingers so that it does not rotate.
- (d) Torque the 4 bolts.
Torque: 61 N·m (620 kgf·cm, 45 ft·lbf)

NOTICE:

Be careful not to damage the teflon ring.

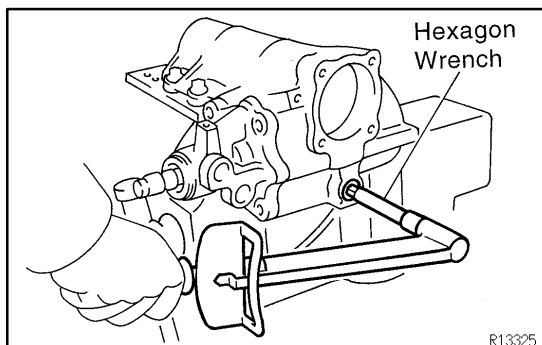


- (e) Using SST and a torque wrench, check the valve body assembly rotating torque.
SST 09616-00010
Rotating torque:
0.3 - 0.5 N·m (3 - 5.5 kgf·cm, 2.6 - 4.8 in·lbf)

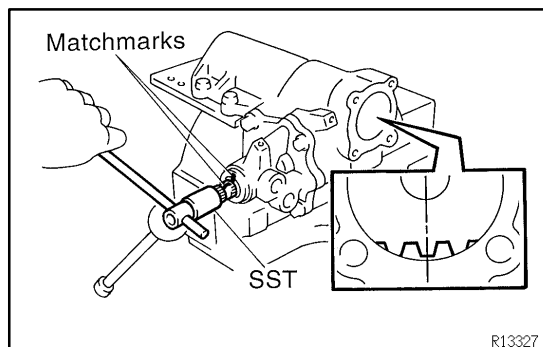
HINT:

Hold the worm gear to prevent it from turning.

If rotating torque is not correct, replace the worm gear valve body assembly.

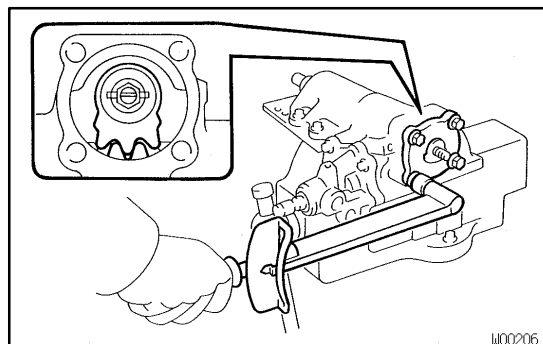


3. INSTALL POWER PISTON PLUNGER GUIDE, POWER PISTON PLUNGER, COMPRESSION SPRING AND POWER PISTON PLUNGER GUIDE NUT
 - (a) Coat a new O-ring with power steering fluid.
 - (b) Install the O-ring to the plunger guide nut and install the plunger guide nut with a hexagon wrench (10 mm).
Torque: 20 N·m (205 kgf·cm, 15 ft·lbf)



4. DETERMINE CENTER POSITION

- Using SST, turn the worm gear valve body shaft so full lock in both directions and determine the exact center.
SST 09616-00010
- Place matchmarks on the worm gear valve body shaft and worm gear valve body housing to show neutral position.



5. INSTALL CROSS SHAFT AND SIDE COVER

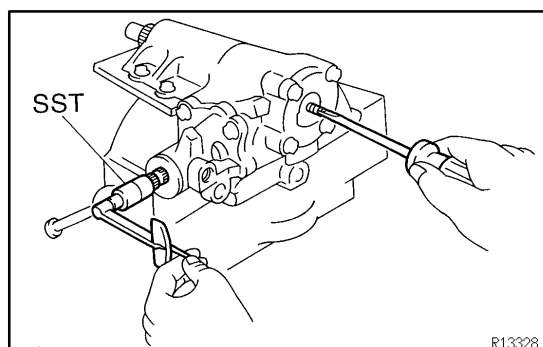
- Coat a new O-ring with power steering fluid and install it on the side cover.
- Assemble the cross shaft to the side cover.

HINT:

Fully loosen the cross shaft adjusting screw.

- Install and push the cross shaft into the gear housing so that the center teeth mesh together.
- Torque the 4 bolts in a diagonal pattern.

Torque: 61 N·m (620 kgf·cm, 45 ft·lbf)



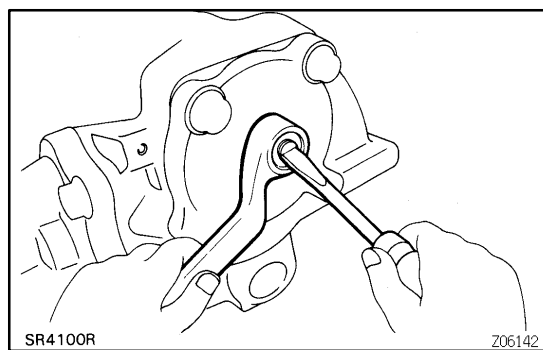
6. ADJUST TOTAL PRELOAD

- Install SST with a torque wrench on the worm gear valve body shaft.
SST 09616-00010
- Turn the cross shaft adjusting screw until the preload is within specification.

Preload (Turning):

0.74 - 10.8 N·m (7.5 - 11.0 kgf·cm, 6.5 - 9.6 in·lbf)

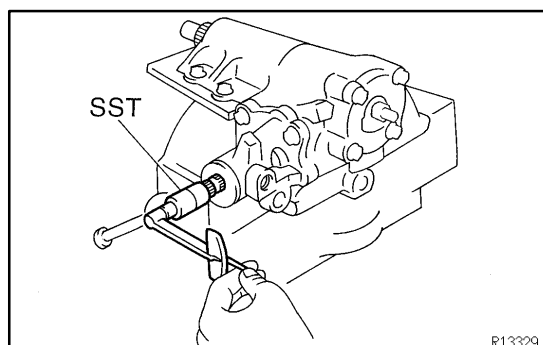
7. INSTALL NEW SEAL WASHER



8. INSTALL ADJUSTING SCREW LOCK NUT

Torque the lock nut while holding the cross shaft adjusting screw.

Torque: 46 N·m (470 kgf·cm, 34 ft·lbf)



9. CHECK TOTAL PRELOAD

Using SST and a torque wrench, check total preload.

SST 09616-00010

Total preload (Turning):

0.74 - 1.08 N·m (7.5 - 11.0 kgf·cm, 6.5 - 9.6 in·lbf)